

12603



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3914-041
Job Sheet 189947

**Part No:** D3914-041**Job Qty:** 1 pcs**Part Name:** Long Basket Lid Assembly (350)**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/1/19**Job Tracking No:****Due Date:** 2/22/19**Created By:** Dara Macdonald**Type:** SOLD**Description:**

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	2/22/19		0.00	6.67	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	1 pcs	2/22/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
120	QC 5	1 pcs	2/22/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

Plex 2/5/19 9:30 AM Dart.Hadley.Shannon

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					Powdercoat - 1 - B4B	
130 Powdercoat - 4 Black Sand - B4B	1 pcs	2/22/19	0.00 0.40		Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
135 QC 3	1 pcs	2/22/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
140 Handfinish - 3-1- WingWalk-B4B	1 pcs	2/22/19	0.00 0.80		QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
150 QC 3	1 pcs	2/22/19	0.00 0.00		QC 3 - 34	
					QC 3 - 36	
					QC 3 - 38	
					QC 3 - 41	
					QC 3 - 51	
160 Packaging 3-1 - Stock - B4B	1 pcs	2/22/19	0.00 0.00		QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	

130 Powdercoat - 4 Black Sand - B4B

1 pcs

2/22/19

0.00 0.40

START: 1:25 O.T. 3:00 FINISH: 1:55

135 QC 3

1 pcs

2/22/19

0.00 0.00

140 Handfinish - 3-1- WingWalk-B4B

1 pcs

2/22/19

0.00 0.80

150 QC 3

1 pcs

2/22/19

0.00 0.00

160 Packaging 3-1 - Stock - B4B

1 pcs

2/22/19

0.00 0.00

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 26

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 38

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 6

QC 3 - 68

QC 3 - 9

Handfinish - 3 - 1 - B4B

Handfinish - 3 - 2 - B4B

Handfinish - 3 - 3 - B4B

Handfinish - 3 - 4 - B4B

Handfinish - 3 - 5 - B4B

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 26

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 38

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 6

QC 3 - 68

QC 3 - 9

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

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					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	DAS 21 FEB 27 2019
					QC 21 - SA - 70	DAS 21 FEB 27 2019
					QC 21 - SA - 53	DAS 21 FEB 27 2019
170 QC 21 - SA	1 pcs	2/22/19	0.00 0.00			

Part Op **100** - (Weld per dwg A/R S.S. rod Batch: _____ - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld
 Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on
 basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure
 to place mesh correctly on lid, check with label plate before tacking mesh***
110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***
135 - QC3- Inspect Part Finish
140 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1- Mask data plate and apply wing walk on outside surface of
 mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand
 area for label, apply label ***
150 - QC3- Inspect Part Finish
160 - Identify as per dwg & Stock Location: _____
170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5146 653
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5151 738
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5154 634
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	5110 937
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	5150 669
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	5153 498
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	5154 733

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	75	0
	D3914-1	2	6	0
	D3914-7	2	8	0
	D4016-3	3	150	0
	D4018-5	9	63	0
	D4020-5	1	2	0
	D4021-3	1	4	0
	D4035-043	2	8	0

Part Specifications

Specifications could not be found.

Plex 2/5/19 9:30 AM Dart.Hadley.Shannon

Master Unit 008245



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K6A 1K7
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D3914-041 Job Sheet 189947



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/1/19

Job Tracking No:

Due Date: 2/22/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/22/19	0.00	0.00	Start Up Large Fab-5		
100	Large Fab	1 pcs		2/22/19	0.00	6.67	Large Fab 1		
110	QC	1 pcs		2/22/19	0.00	0.00	QC9		
120	QC	1 pcs		2/22/19	0.00	0.00	QC5		
130	Powdercoat	1 pcs		2/22/19	0.00	0.40	Powdercoat4		
135	QC	1 pcs		2/22/19	0.00	0.00	QC3		
140	HandFinish	1 pcs		2/22/19	0.00	0.80	HandFinish3		
150	QC	1 pcs		2/22/19	0.00	0.00	QC3		
160	Packaging	1 pcs		2/22/19	0.00	0.00	Packaging3-2		
170	QC21-SA	1 Ea		2/22/19	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***
130 - *** mask sides of hinge prior to powdercoat***
140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	90-Start up Operation	5146653
D3914-1 ✓	Rib	2 pcs (2 ea) ✓	90-Start up Operation	5151738
D3914-7 ✓	Rib	2 pcs (2 ea) ✓	90-Start up Operation	5154634
D4016-3 ✓	Hinge Half, Lid	3 pcs (3 ea) ✓	90-Start up Operation	5110937
D4018-5 ✓	Rib	9 pcs (9 ea) ✓	90-Start up Operation	5150669
D4020-5 ✓	Mesh (350 Basket Long, Lid)	1 pcs (1 ea) ✓	90-Start up Operation	5153498
D4021-3 ✓	Data Plate	1 pcs (1 ea) ✓	90-Start up Operation	5154112
D4035-043 ✓	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea) ✓	90-Start up Operation	5154733

Missing

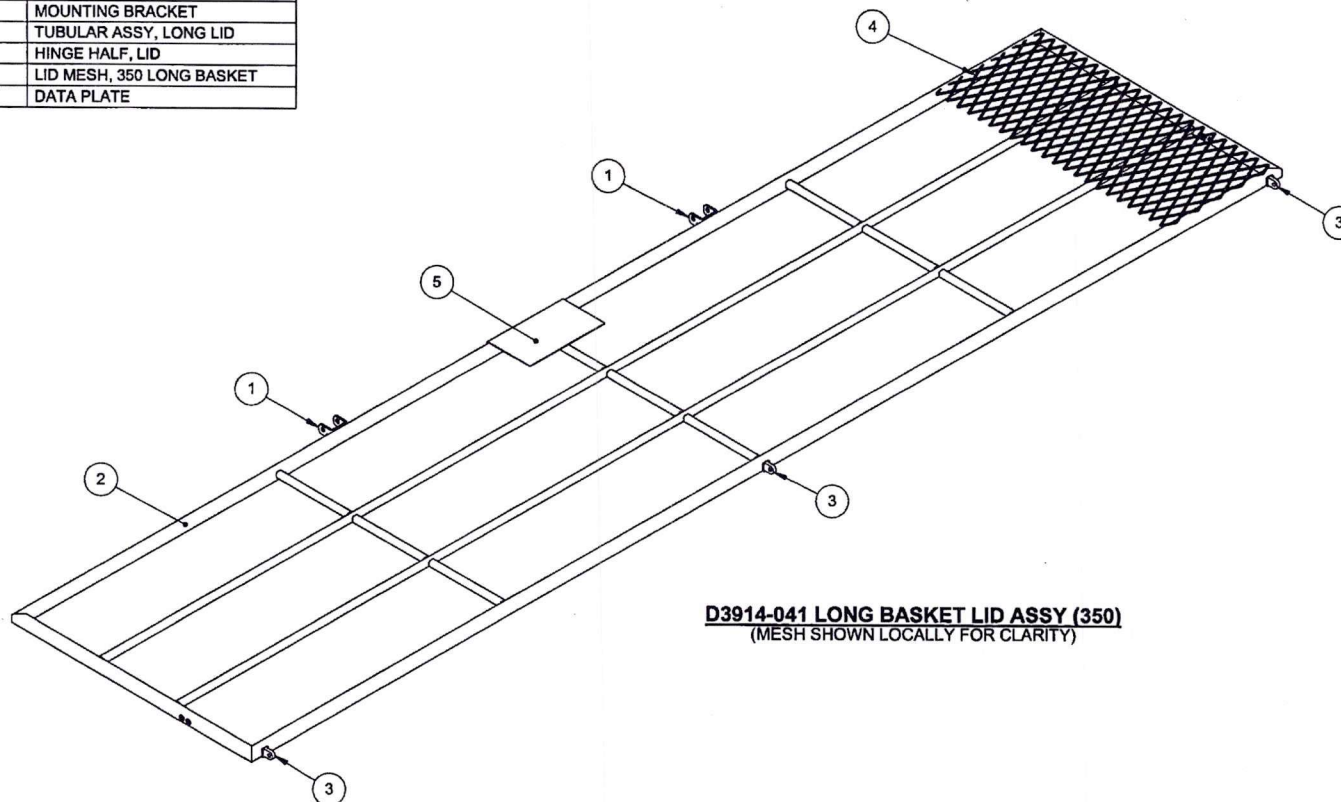
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	79	0
	D3914-1	2	8	0
	D3914-7	2	10	0
	D4016-3	3	153	0
	D4018-5	9	42	0
	D4020-5	1	3	0
	D4021-3	1	5	0
	D4035-043	2	10	0

Part Specifications

Specifications could not be found.

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	1	D3914-101	TUBULAR ASSY, LONG LID
3	3	D4016-3	HINGE HALF, LID
4	1	D4020-5	LID MESH, 350 LONG BASKET
5	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

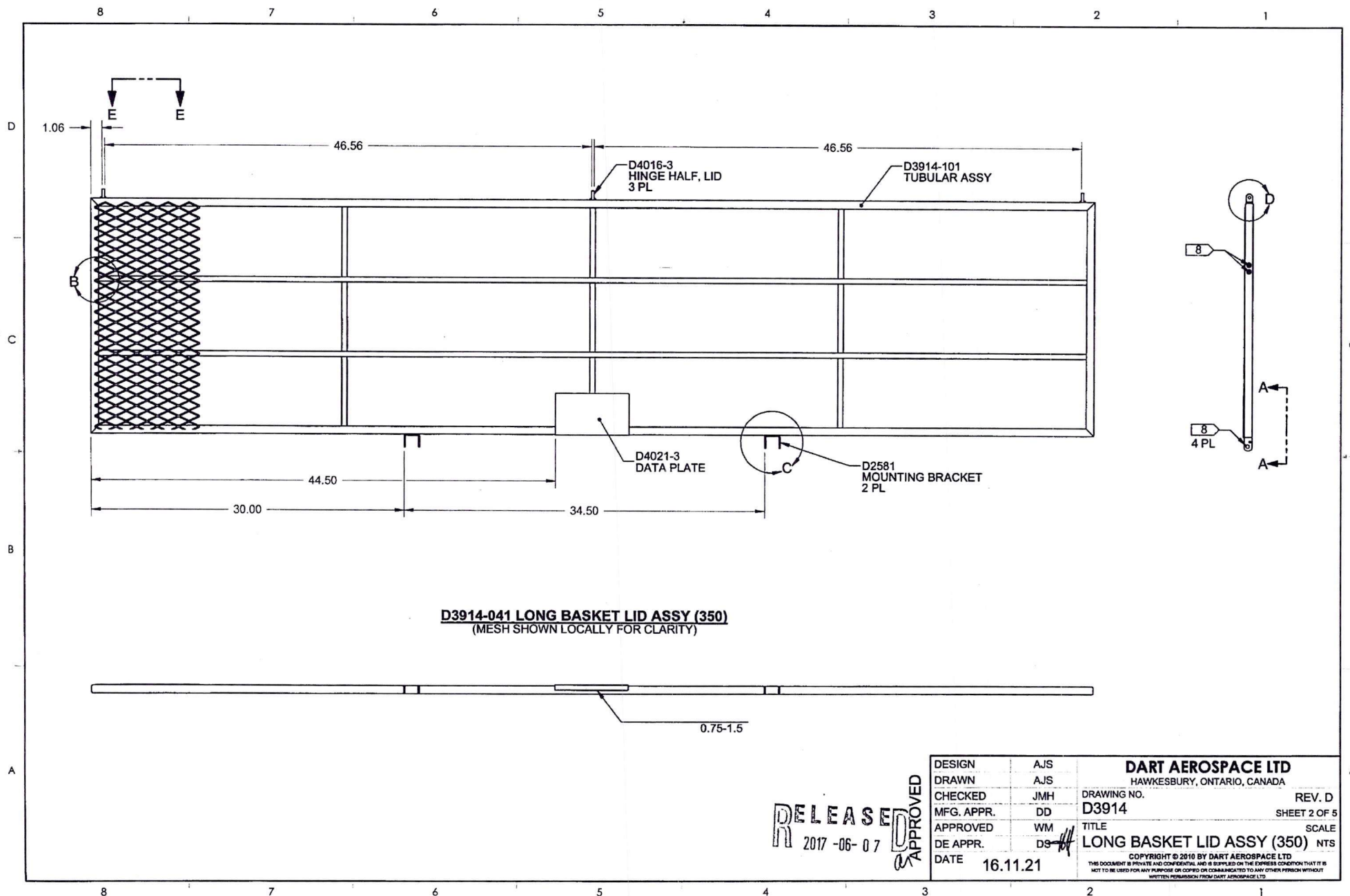
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004
- 10) MASK THIS AREA PRIOR TO FINISH

D	SHEET 1: UPDATED NOTE 6 ADDED NOTE 10. D2728-3 DELETED. SHEET 2: SECTION AND VIEW LETTERS UPDATED. ADDED VIEW E-E. (PAR15-418)	AJS	16.11.21
C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROPARM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2017-06-07
ECN 17-580

APPROVED



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

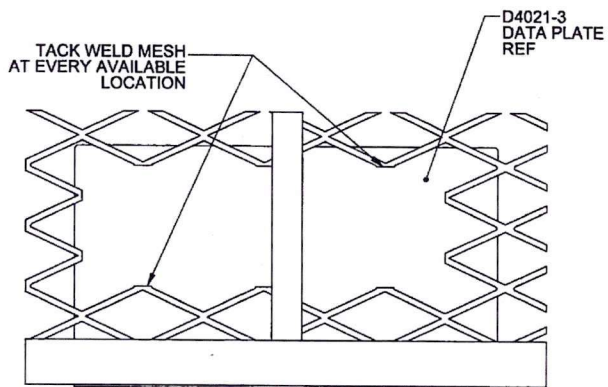
RELEASED
2017-06-07

APPROVED

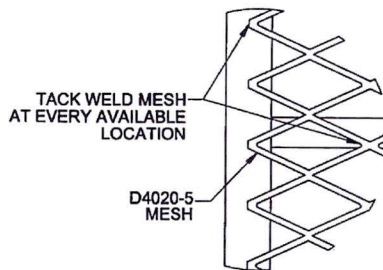
DESIGN	AJS
DRAWN	AJS
CHECKED	JMH
MFG. APPR.	DD
APPROVED	WM
DE APPR.	D9
DATE	16.11.21

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3914	REV. D SHEET 2 OF 5
TITLE LONG BASKET LID ASSY (350) NTS	
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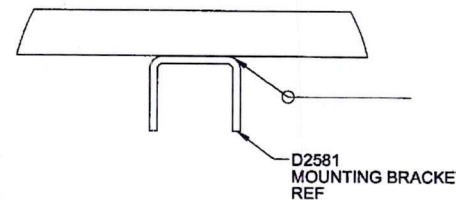
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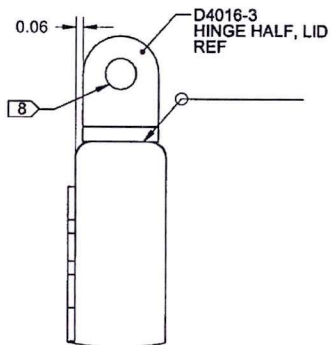
VIEW A-A
SCALE 4X



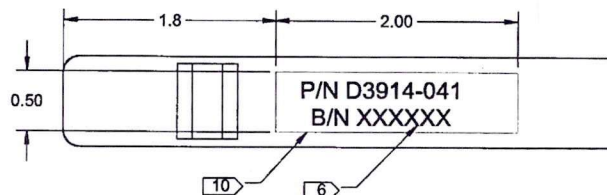
DETAIL B
SCALE 4X



DETAIL C
SCALE 4X
2 PL



DETAIL D
SCALE 8X
3 PL



VIEW E-E
SCALE 8X

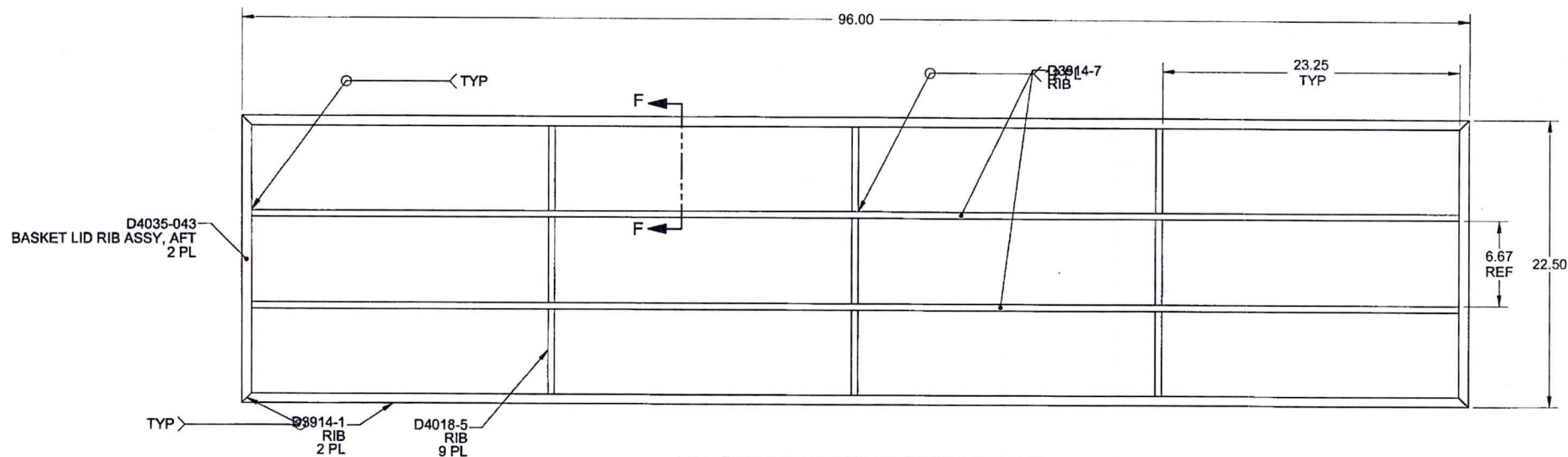
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO. D3914	REV. D
MFG. APPR.	DD	SHEET 3 OF 5	
APPROVED	WM	SCALE	
DE APPR.	DS	LONG BASKET LID ASSY (350) NTS	
DATE	16.11.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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2017-06-07

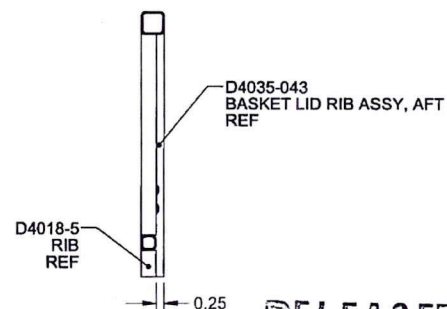
APPROVED

8 7 6 5 4 3 2 1

8		7	
ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



8 D3914-101 TUBULAR ASSY, LONG LID



NOTES:

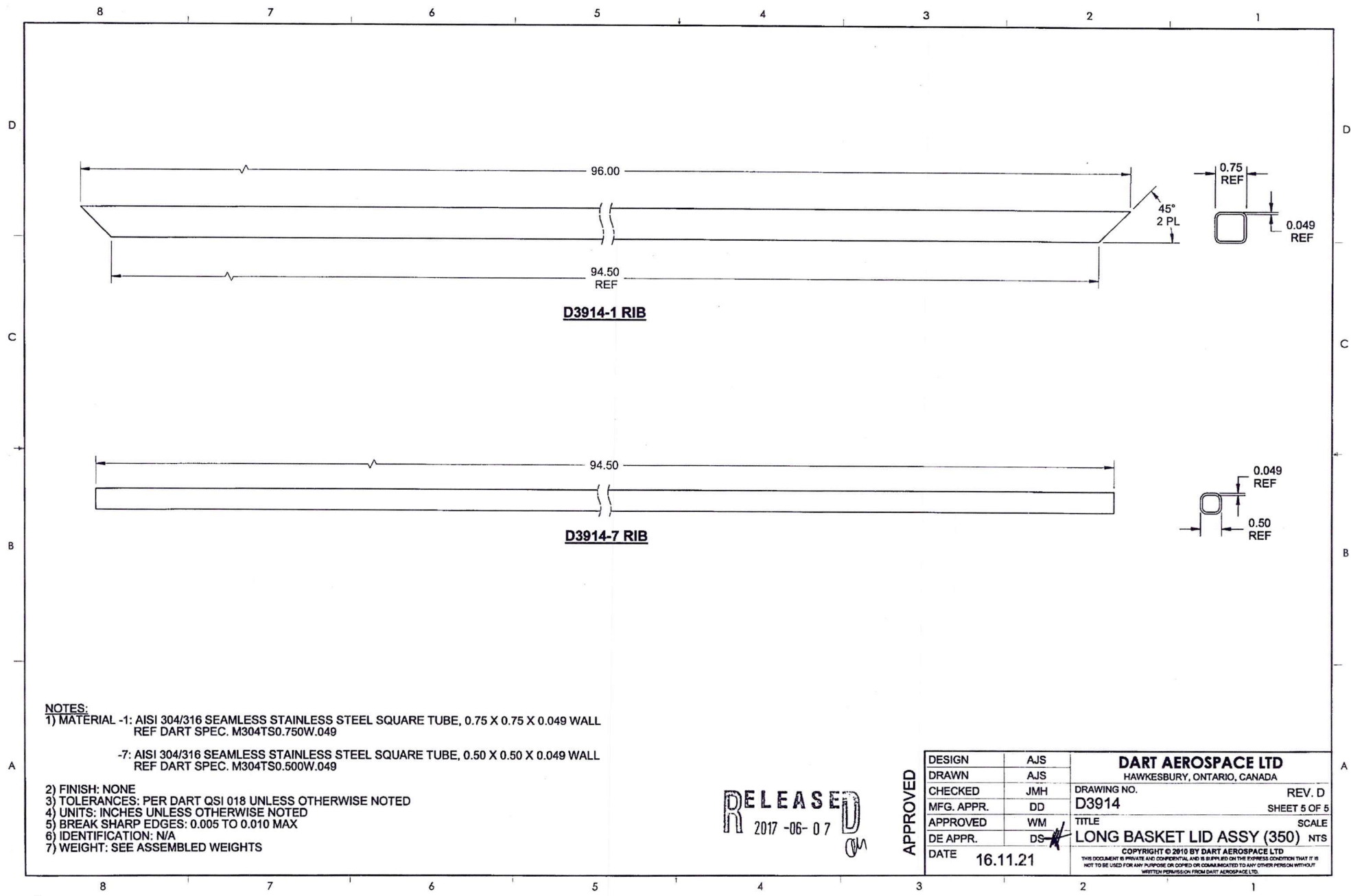
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS 0.06 FOR D3914-101
 - 9) WELD PER DART QSI 004

SECTION F-F
SCALE 2X

RELEAS
2017-06-01

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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 TITLE LONG BASKET LID ASSY (350) COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR ANY COMMERCIAL PURPOSES TO ANY OTHER PARTY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. D
DRAWN	AJS		SHEET 4 OF 5
CHECKED	JMH		SCALE
MFG. APPR.	DD		NTS
APPROVED	WM		
DE APPR.	DS		
DATE	16.11.21		



NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2017-06-07

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 5 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S155997



Part: D3914-041

Job No: 189947

Serial No/Batch: S155997

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/25/19